



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4072-1

Job Sheet 172580



Part No: D4072-1

Job Qty: 20 ea

Part Name: Airframe Hinge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B SHEET 1 Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	3/8/18	3/8/18	0.00	0.00	Start Up Machining-2		18/03/14
100	Bandsaw	20 pcs	3/8/18	3/8/18	0.00	0.29	Bandsaw1		18/03/14
105	CNC Vertical Machining	20 pcs	3/8/18	3/8/18	0.20	8.89	HAAS1-4		18/03/14
110	QC	20 pcs	3/8/18	3/8/18	0.00	0.00	QC2 Machining-2		18/03/14
120	QC	20 pcs	3/8/18	3/8/18	0.00	0.00	QC8 Machining-2		18/03/14
150	HandFinish	20 pcs	3/8/18	3/8/18	0.00	0.37	HandFinish1		2018-3-19 SA
160	Powdercoat	20 pcs	3/9/18	3/9/18	0.00	0.35	Powdercoat2		18/03/14
170	QC	20 pcs	3/9/18	3/9/18	0.00	0.00	QC3		18/03/14
180	Packaging	20 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3-2		18/03/14
190	QC21-SA	20 Ea	3/9/18	3/9/18	0.00	0.00	QC21		18/03/14

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.500	6061-T6 Bar 1.00 X 2.50	2.0800 ft (.104 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.500	2	17	0

Part Specifications

Specifications could not be found.

Plex 2/20/18 2:43 PM Dart.Gagnon.Michelle

1.25X20 → FM 137363 Et=2.1 Ft
SOS1317



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Container No: S051319



Part: D4072-1

Job No: 172580

Serial No/Batch: S051319

Revision:

Inspector:

Date: 03/14/18

DART AEROSPACE LTD		Work Order:	172580
Description: Airframe Hinge		Part Number:	D4072-1
Inspection Dwg: D4072	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	0.500x-125	U		Ver	
2.00	+/-0.030	2.001	U		Ver	
Ø0.203	+0.005/-0.001	Ø0.203	U		G.P.	
0.750	+/-0.010	.752	U		Ver	
R0.06	+/-0.030	R.0.06	U		R.G.	
0.45	+/-0.030	0.449	U		Ver	
1.100	+/-0.010	1.099	U		Ver	
R0.38	+/-0.030	R.0.38	U		R.G.	
0.375	+/-0.010	.373	U		Ver	
0.688	+/-0.010	.689	U		H.G.	
0.275	+/-0.010	.273	U		Ver	
R0.13	+/-0.030	R.0.13	U		R.G.	
0.25	+/-0.030	0.249	U		Ver	
1.06	+/-0.030	1.061			H.G.	
0.125	+/-0.010	0.127	U		Ver	
0.86	+/-0.030	0.864	U		H.G.	
Ø0.323	+0.005/-0.001	.326	U		Ver	

Measured by: DAS 52 9-89	Audited by:	Preliminary Approval:
Date: 18/07/13	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	
B	11.10.13	Dimension 0.25 removed	KJ	